

Date: Friday, 24/04/2009 12:40:30 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PIN ASSEMBLY
Job Number : 47466	
Estimate Number : 11341	
P.O. Number :	Part Number : D3332043 <i>FR</i>
This Issue : 24/04/2009 S.O. No. :	Drawing Number : D3332 REV. A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A1
Previous Run : 44366	Material :
Written By :	Due Date : 30/04/2009 Qty: 6 Um: Each
Checked & Approved By : <i>JLD 09.04.24</i>	
Comment : Est: A 05.01.13 New issue KJJLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1018R0500	1018-1025 round bar .500
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Comment: Qty.: 0.1749 f(s)/Unit Total : 1.0496 f(s)
 1018-1025 Steel Bar
 Material: AISI 1018-1025 Ø0.500" Round Bar
 (M1018-R0.500)
 Identify for D3332-7
 Batch: *M110457*

09.05.04

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL
 Machine D3332-7 as per Folio FA493 and Dwg D3332

09.05.04

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09.05.04 (6)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 09.05.05

5.0	M1018R0313	1018-1025 round bar .313
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Comment: Qty.: 0.2836 f(s)/Unit Total : 1.7016 f(s)
 1018-1025 Steel Bar
 Material: AISI 1018-1025 Ø0.313" Round Bar
 (M1018-R0.313)
 Identify as D3332-9
 Batch: *M107436*

09.06.02 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: PIN ASSEMBLY

Job Number: 47466

Part Number: D3332043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Fabricate D3332-9 as per Dwg D3332

PL 09-06-02

7.0

D33321

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Handle Assembly

Pick:

Qty Part Number Description Batch

1 D3332-1 Handle

A/R N/A

Steel Rod

Identify as D3332-043

B47613 → 4 B47801 → 2
M9326

PL 09-06-02

6

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Assemble and Weld using D3332-041T1 as per Dwg D3332

PL 09-06-02

6

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 0266102

BE 09-06-02

6

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 09-06-02

6

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3
Cover thread only for D3332-9 prior to painting

M 102391

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:30
320°
3:00

PL 09-06-04

6

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Drawing Name: PIN ASSEMBLY

Job Number: 47466

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP per ship

9/6/5 (6)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



12.06.09

W/O:		WORK ORDER CHANGES					
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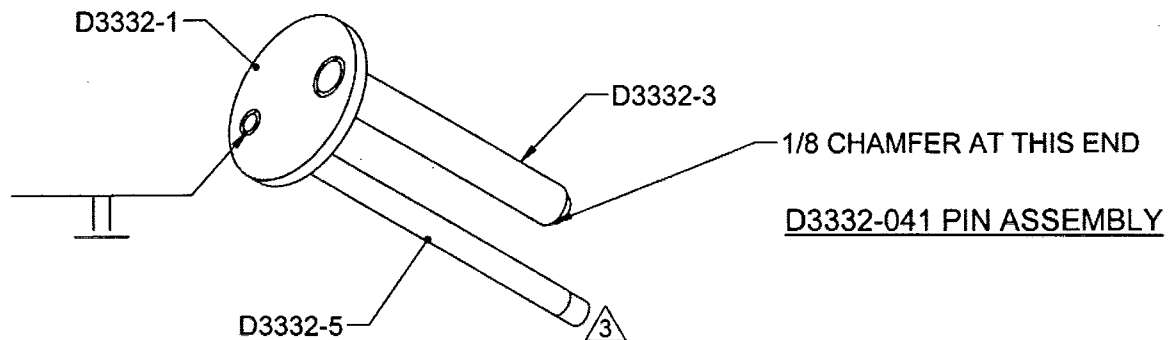
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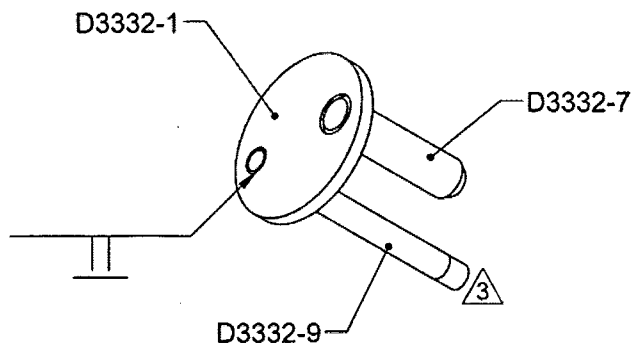
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3332	REV. A SHEET 1 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:2
A	04.12.14	NEW ISSUE	
A1	05.07.04	0.080 WAS 0.050; ADD TOLERANCE ± 0.000 ± 0.005	

**D3332-041 PIN ASSEMBLY**

RELEASED
05/02/09

**D3332-043 PIN ASSEMBLY****NOTES:**

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) MASK THREADS PRIOR PAINTING
- 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
(COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

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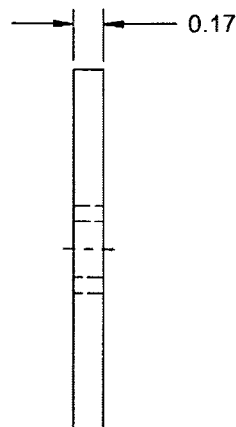
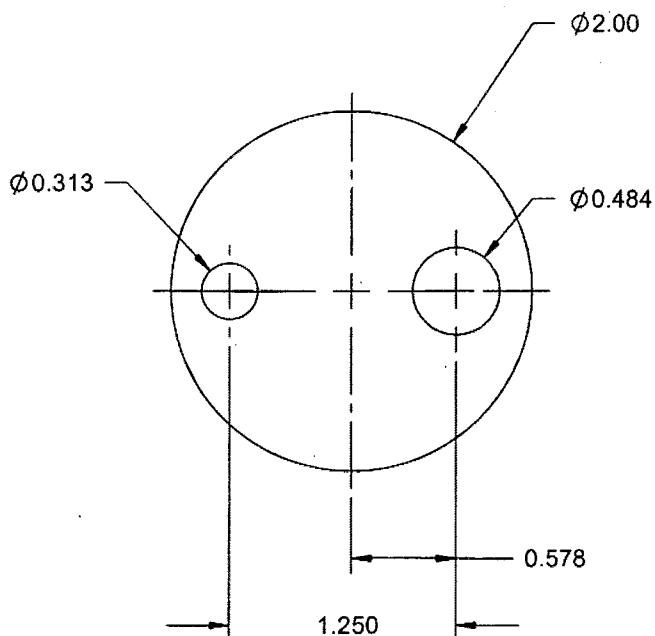
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



RELEASED
AS
5/6/09

D3332-1 HANDLE**NOTES:**

- 1) MATERIAL: 1018-25 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018-R2.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

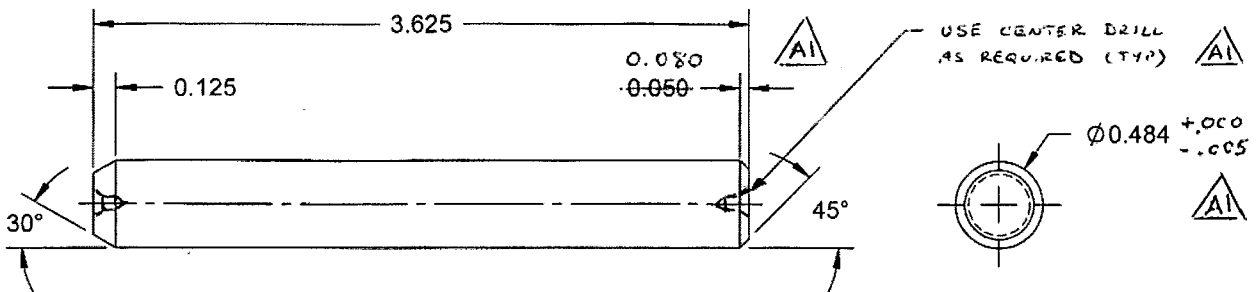
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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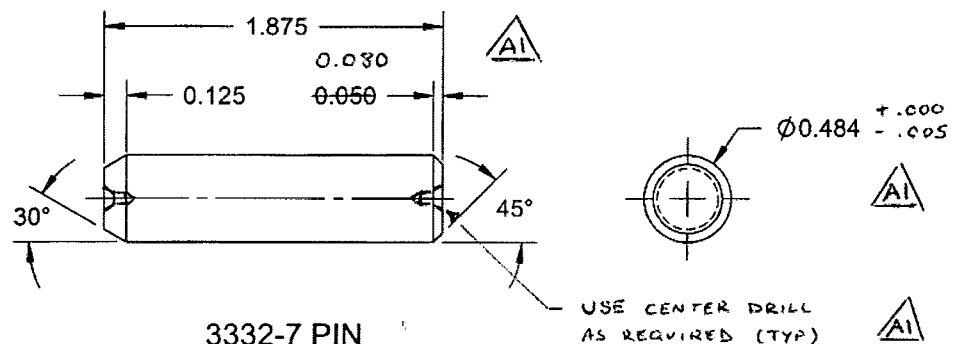
NOTE: Date & initial all entries

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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1

**3332-3 PIN**

RELEASED
ds
05/02/09

**3332-7 PIN****NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

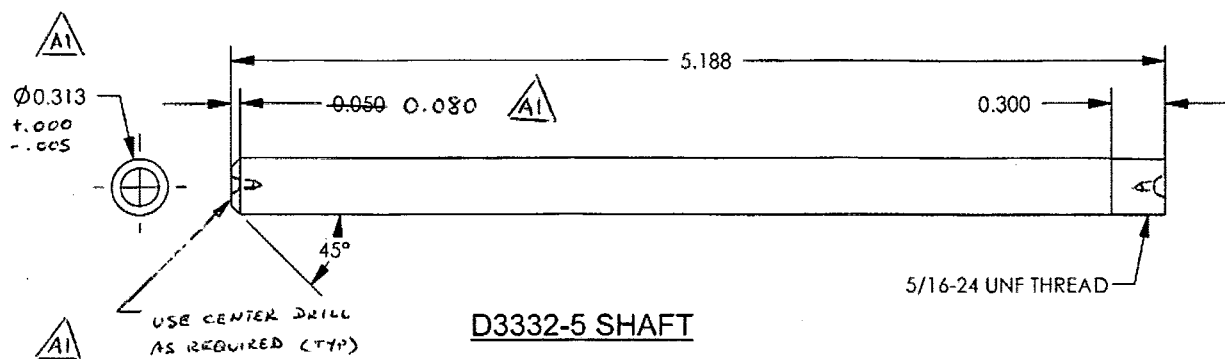
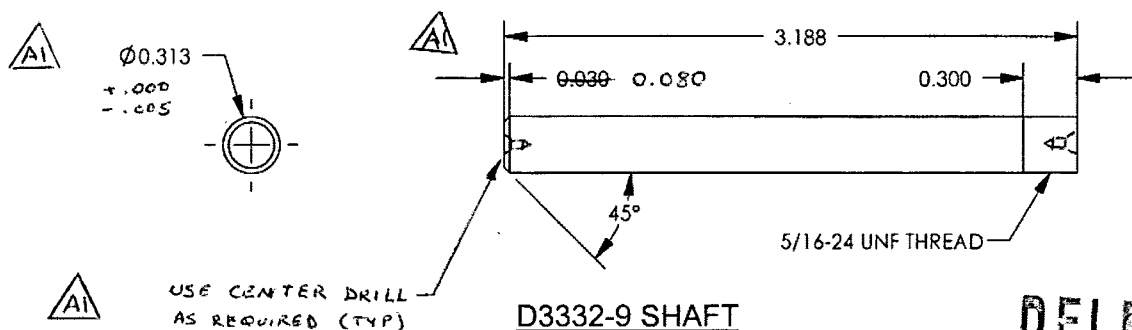
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1

**D3332-5 SHAFT****D3332-9 SHAFT**

RELEASED
[Signature]
05/02/09

NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

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